

Date: Tuesday, 19/08/2008 4:05:01 PM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 41456  
 Estimate Number : 11294  
 P.O. Number :  
 This Issue : 19/08/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : // Type : MACHINED PARTS  
 Previous Run : 41205  
 Written By :  
 Checked & Approved By : JLP 08-8-19  
 Comment : Est. A 05.06.30 New issue KJ/JLM

Drawing Name : TUBE DETENT CLIP BASE  
 Part Number : D34409  
 Drawing Number : D3440 REV A  
 Project Number : N/A  
 Drawing Revision : A  
 Material :  
 Due Date : 18/09/2008 Qty: 10 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1250X01250 6061-T6 Bar 1.25 x 1.25



Comment: Qty.: 0.1706 f(s)/Unit Total: 1.7063 f(s)

*no matt in computer*

6061-T6 Bar 1.25 x 1.25"

Material: 6061-T6 Bar 1.250" x 1.250"

(M6061T6B1.250x01.250)

Identify for D3440-9

Batch: M106259

*mf 08/08/27*

(10)

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blank: 1.250" x 1.250" x 1.825" long

*mf 08/08/27*

(10)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA535 and Dwg D3440

Dwg Rev: A

Identify as D3440-9

Folio Rev: AA

Deburr

*JL 08/08/29* *PTC*

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*JL 08/08/29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3440-9 PAR #: N/A Fault Category: Prod/Machined Parts NCR: Yes No DQA: D Date: 08/08/29  
D350-591-3440-2  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: D Date: 08/08/29

NCR: <u>41456</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/08/29</u>	<u>3</u>	<u>2 parts tap broke in hole</u>	<u>[Signature]</u> <u>08/08/29</u>	<u>- scrap + replace</u> <u>PM 106259</u>	<u>SL</u> <u>08/08/29</u>	<u>[Signature]</u> <u>08/08/29</u>	<u>[Signature]</u> <u>08/08/29</u>	<u>[Signature]</u> <u>08/08/29</u>

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:05:01 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE DETENT CLIP BASE

Job Number: 41456

Part Number: D34409

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*28 08/08/29*

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5793*

*LC 8/12/29 (14)*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/09/02*

Job Completion



*MF 08-08-29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

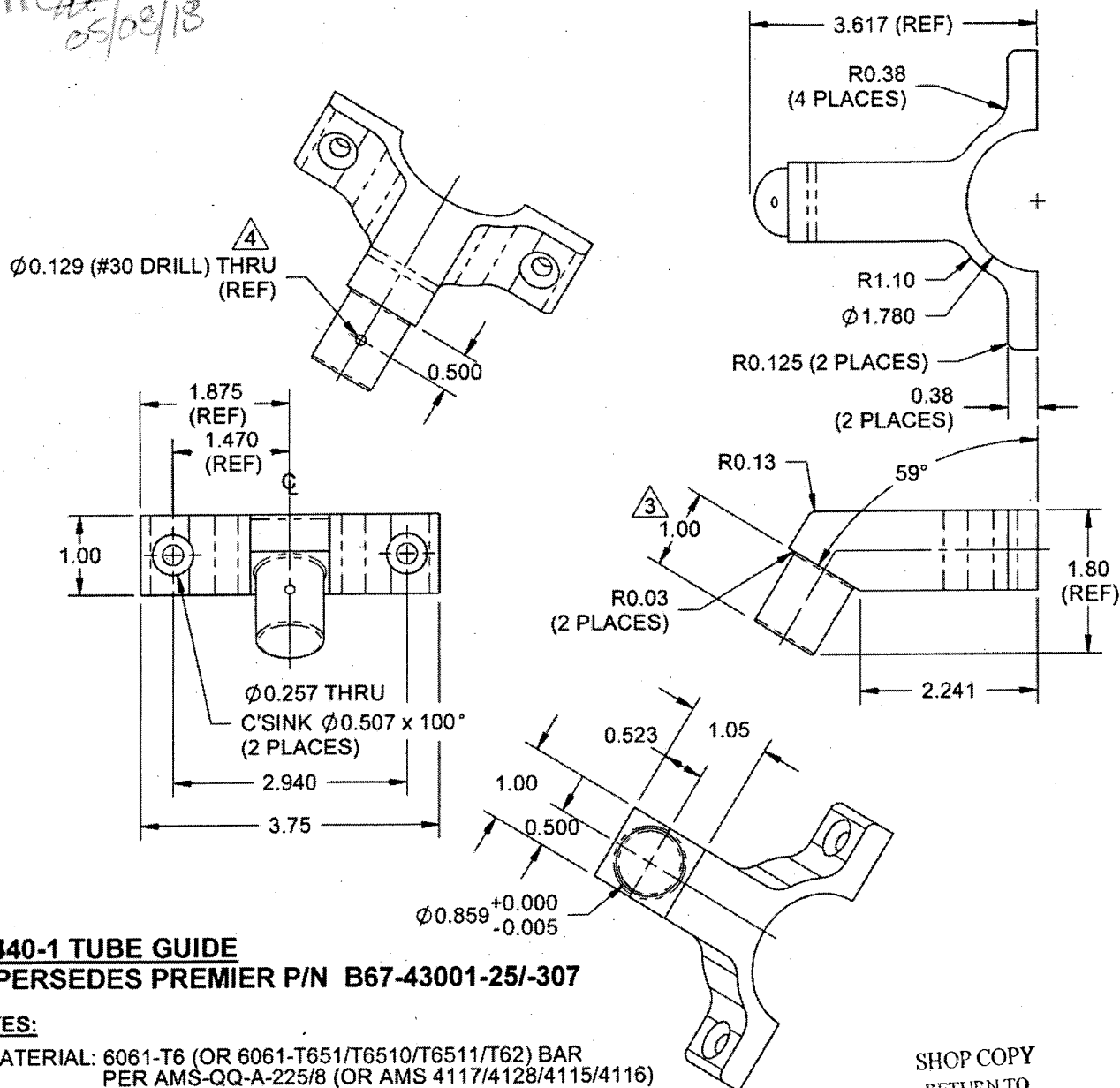
**NOTE:** Date & initial all entries





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DATE <b>05.06.02</b>	TITLE <b>BLADE FOLD KIT PARTS</b>		SCALE 1:2
A	05.06.02	NEW ISSUE	

RELEASED  
05/08/18



**D3440-1 TUBE GUIDE**  
**SUPERSEDES PREMIER P/N B67-43001-25/-307**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QQ/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) MASK BEFORE PAINTING.
- 4) DRILL HOLE AT ASSEMBLY.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES  $0.005$  TO  $0.010$

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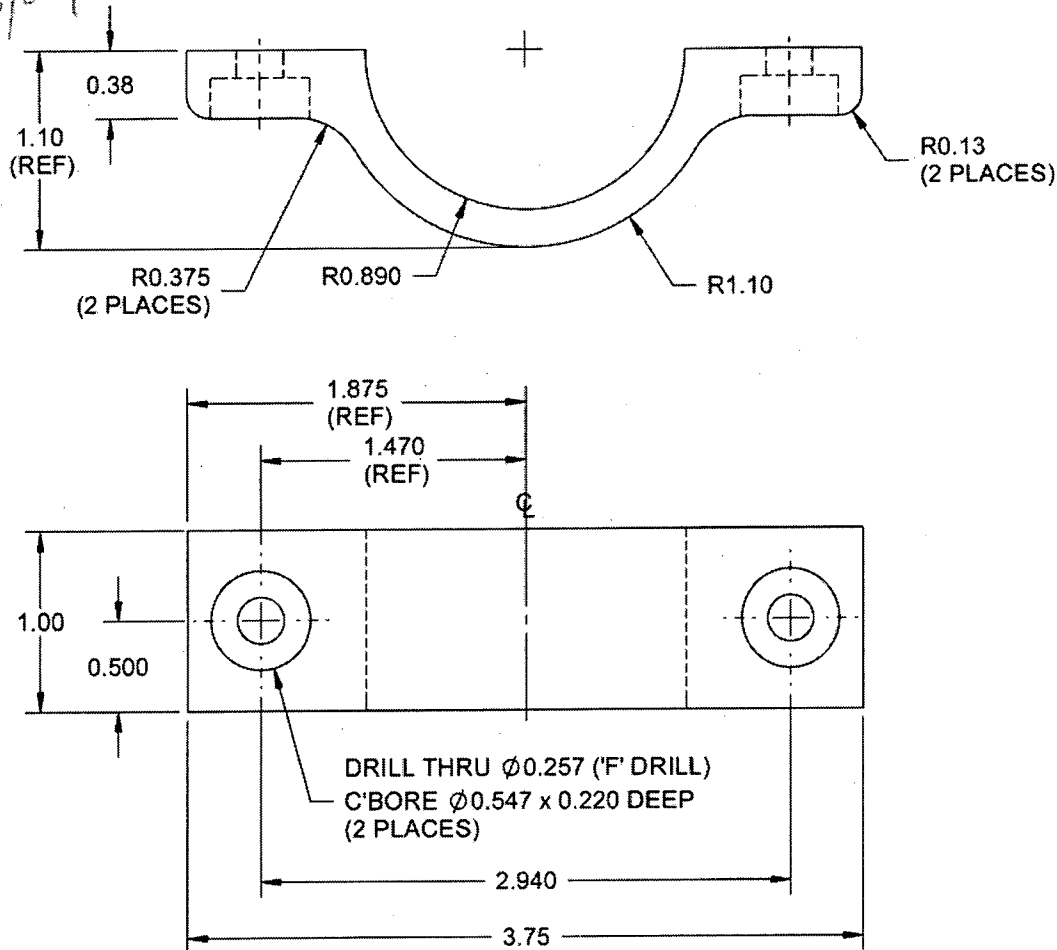
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DATE <b>05.06.02</b>	TITLE <b>BLADE FOLD KIT PARTS</b>		SCALE 1:1

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05/08/18



**D3440-3 CLAMP**  
**SUPERSEDES PREMIER P/N B67-43001-309**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QT/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3 WITHOUT NOTICE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. 41456

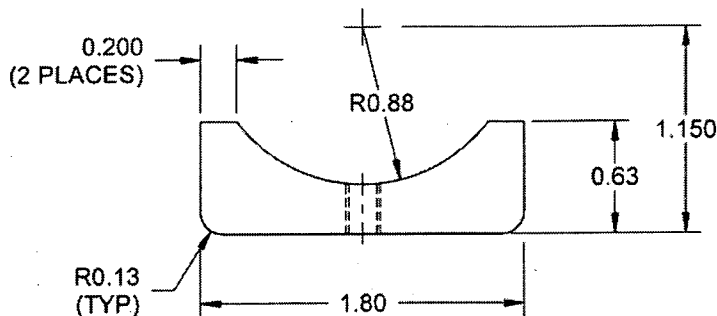
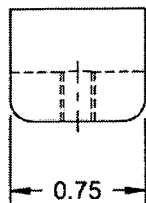
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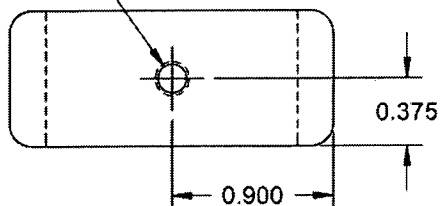


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DATE <b>05.06.02</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:1

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05/08/18



DRILL  $\varnothing 0.159$  THRU,  
TAP #10-32 UNF THRU



**D3440-5 CONTOURED DETENT CLIP BASE**  
**SUPERSEDES PREMIER P/N B67-43001-217**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QQ/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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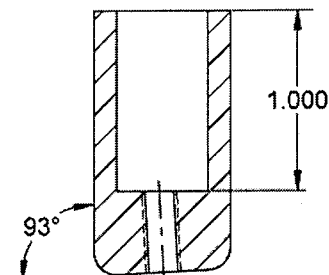
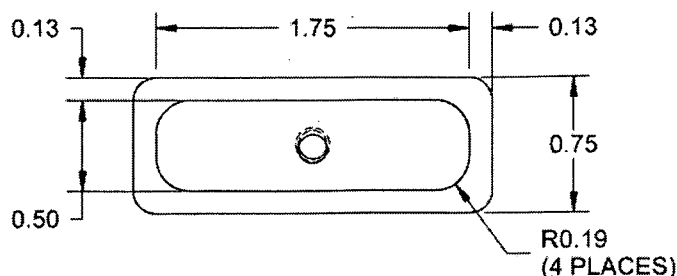
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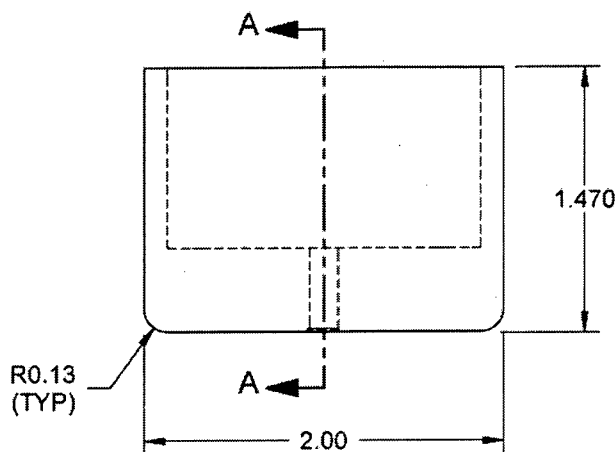
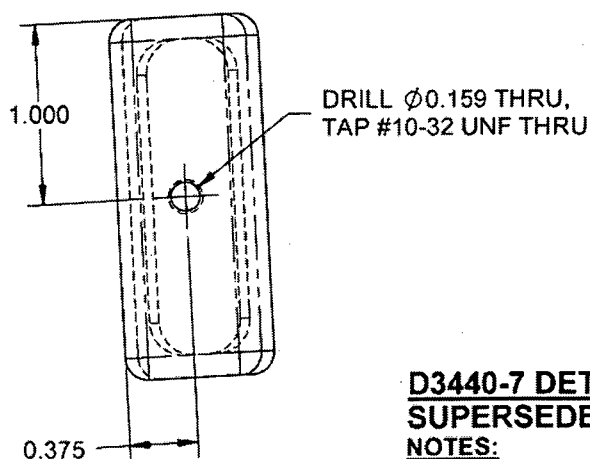


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DATE <b>05.06.02</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:1

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SECTION A-A



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**D3440-7 DETENT CLIP BASE**

**SUPERSEDES PREMIER P/N B67-43001-221**

**NOTES:**

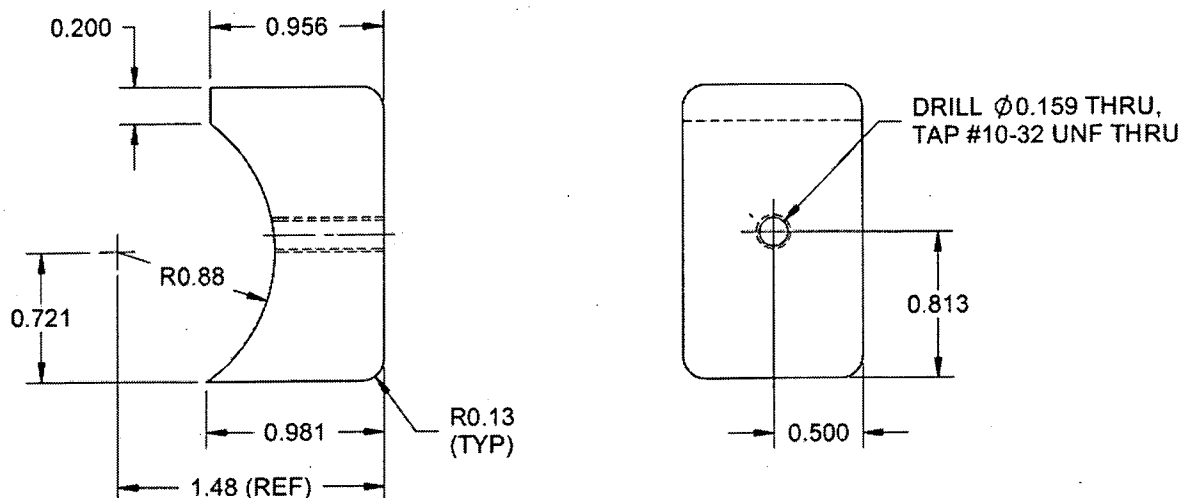
- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QQ/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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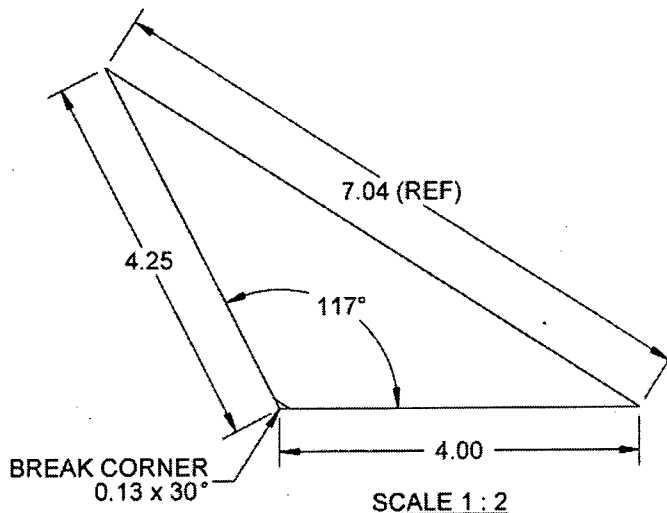
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DATE <b>05.06.02</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:1



**D3440-9 TUBE DETENT CLIP BASE**  
**SUPERSEDES PREMIER P/N B67-43001-241**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS-QQ-A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)

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05/08/18



**D3440-11 GUSSET**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.250)

**NOTES:**

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) ALL DIMENSIONS ARE IN INCHES  
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

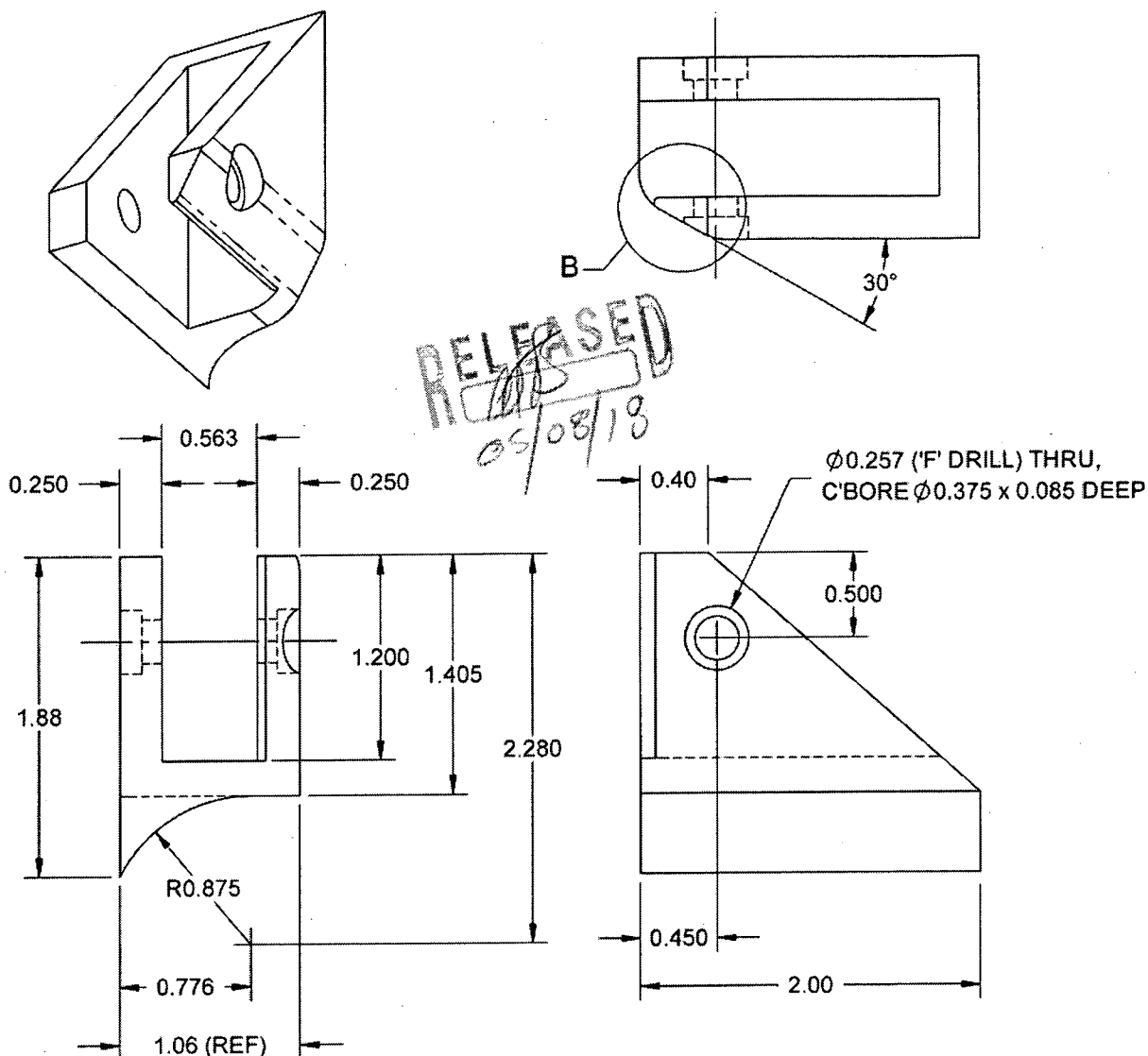
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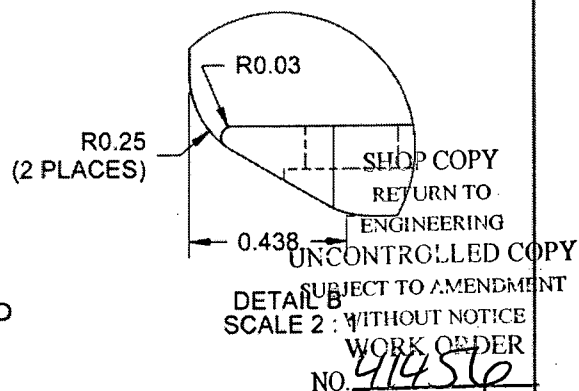
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DATE <b>05.06.02</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:1



**D3440-13 BRACKET**  
**SUPERSEDES PREMIER P/N B67-43001-273**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QQ/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



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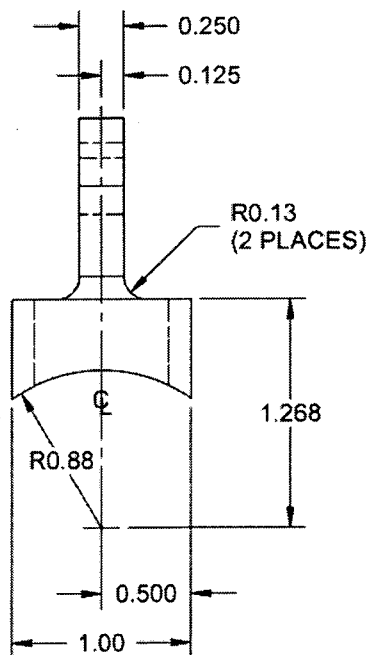
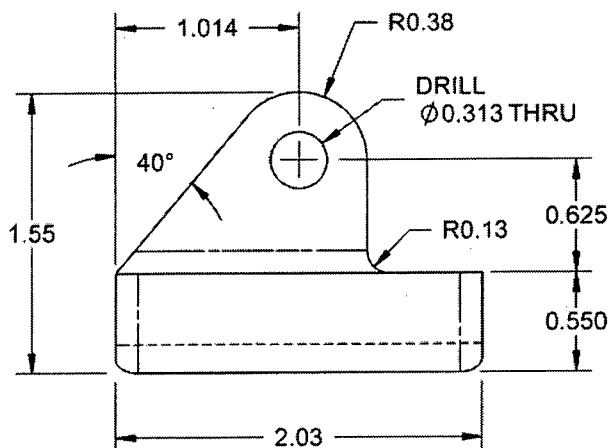
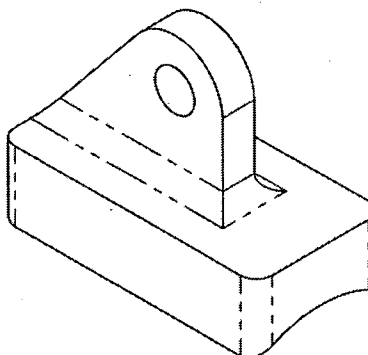
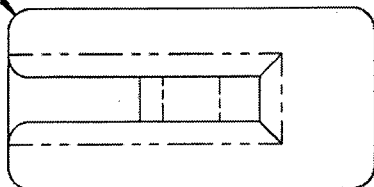
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DATE <b>05.06.02</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:1

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*[Signature]*  
05/08/18

R0.13  
(4 PLACES)



**D3440-15 CONTOURED MALE EYE**  
**SUPERSEDES PREMIER P/N B67-43001-215**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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